

50.8

NO MAG??

Dart Aerospace Ltd.

Date: Wednesday, 18/06/2008 1:26:36 PM
User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE BLOCK
Job Number : 39919
Estimate Number : 10324
P.O. Number :
This Issue : 18/06/2008 S.O. No. :
Prsht Rev. : NC
First Issue : // Type : MACHINED PARTS
Previous Run : 38274
Written By :
Checked & Approved By : JUL 08.6.18
Comment : Est RevC 02.04.10 Re-format NG

Part Number : D1049
Drawing Number : D1049 REV A
Project Number : N/A
Drawing Revision : A
Material :
Due Date : 11/07/2008 Qty: ~~80~~ 50 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M6061T6B0750X00250 6061-T6 Bar .750 x .250



Comment: Qty.: 0.1749 f(s)/Unit Total : 8.7465 f(s)
Material: 6061-T6 bar .750 wide x .250 thick.
Batch M107904

2.0 SHEAR SHEAR



Comment: SHEAR
Cut Blanks: 2.000" long

SD 08/07/04

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per folio FA217 & Dwg D1049

2-Deburr

SD 08/07/04

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SD 08/07/04

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SD 08/07/04

POSITIVE RECALL

EFFECTIVE 08/07/04 AUTH LS

RELEASED u DATE 08/07/04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 18/06/2008 1:26:36 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE BLOCK

Job Number: 39919

Part Number: D1049

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(54)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 08-07-08

7.0

POWDER COATING

POWDER COATING



m102316

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

(54)

START TIME:

11:30

OVEN TEMPERATURE:

320

FINISH TIME:

12:00

12/17 08/07/09

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

18 08/07/10

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 2

18 08/07/10 (54)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/10

Job Completion



MF 08-07-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

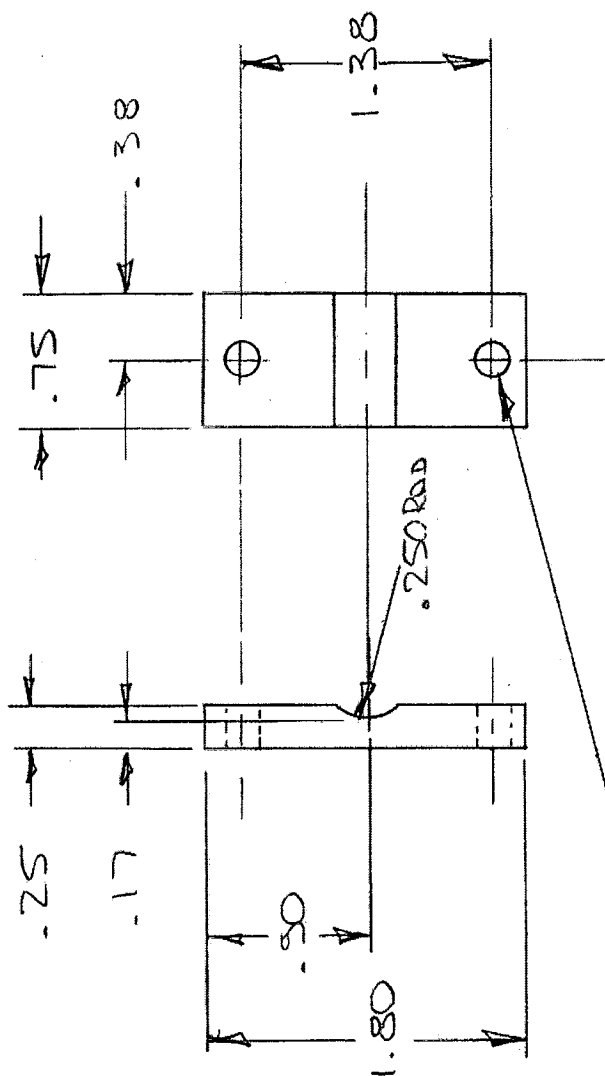
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

97/08/02 Bv



203 DIA.
TIP

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39119

MATERIAL : SOSZ-H32

W/ Z/ S/ I/ ..
POWDER
LOGG



REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPD OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF GALT AERO.										REPORT ALL DISCREPANCIES — DO NOT SCALE									
DRAWN																				
APPROVED																				
DESCRIPTION OF CHANGE	REQUIREMENTS — LINKS OTHERWISE SPECIFIED GENERAL LIMITS 1. TOLERANCES — SEE 2.310 2. DIMENSIONS ARE IN INCHES 3. FINISHES — UNLESS NOTED 4. MATERIALS — SEE 2.310 5. THREADS — SHARP POINTS .015 MAX 6. IMPREGNATION — SEE 2.310 7. TOLERANCES — SEE 2.310 8. FINISHES — UNLESS NOTED 9. MATERIALS — SEE 2.310 10. THREADS — SHARP POINTS .015 MAX 11. IMPREGNATION — SEE 2.310 12. TOLERANCES — SEE 2.310 13. FINISHES — UNLESS NOTED 14. MATERIALS — SEE 2.310 15. THREADS — SHARP POINTS .015 MAX 16. IMPREGNATION — SEE 2.310 17. TOLERANCES — SEE 2.310 18. FINISHES — UNLESS NOTED 19. MATERIALS — SEE 2.310 20. THREADS — SHARP POINTS .015 MAX 21. IMPREGNATION — SEE 2.310 22. TOLERANCES — SEE 2.310 23. FINISHES — UNLESS NOTED 24. MATERIALS — SEE 2.310 25. THREADS — SHARP POINTS .015 MAX 26. IMPREGNATION — SEE 2.310 27. TOLERANCES — SEE 2.310 28. FINISHES — UNLESS NOTED 29. MATERIALS — SEE 2.310 30. THREADS — SHARP POINTS .015 MAX 31. IMPREGNATION — SEE 2.310 32. TOLERANCES — SEE 2.310 33. FINISHES — UNLESS NOTED 34. MATERIALS — SEE 2.310 35. THREADS — SHARP POINTS .015 MAX 36. IMPREGNATION — SEE 2.310 37. TOLERANCES — SEE 2.310 38. FINISHES — UNLESS NOTED 39. MATERIALS — SEE 2.310 40. THREADS — SHARP POINTS .015 MAX 41. IMPREGNATION — SEE 2.310 42. TOLERANCES — SEE 2.310 43. FINISHES — UNLESS NOTED 44. MATERIALS — SEE 2.310 45. THREADS — SHARP POINTS .015 MAX 46. IMPREGNATION — SEE 2.310 47. TOLERANCES — SEE 2.310 48. FINISHES — UNLESS NOTED 49. MATERIALS — SEE 2.310 50. THREADS — SHARP POINTS .015 MAX 51. IMPREGNATION — SEE 2.310 52. TOLERANCES — SEE 2.310 53. FINISHES — UNLESS NOTED 54. MATERIALS — SEE 2.310 55. THREADS — SHARP POINTS .015 MAX 56. IMPREGNATION — SEE 2.310 57. TOLERANCES — SEE 2.310 58. FINISHES — UNLESS NOTED 59. MATERIALS — SEE 2.310 60. THREADS — SHARP POINTS .015 MAX 61. IMPREGNATION — SEE 2.310 62. TOLERANCES — SEE 2.310 63. FINISHES — UNLESS NOTED 64. MATERIALS — SEE 2.310 65. THREADS — SHARP POINTS .015 MAX 66. IMPREGNATION — SEE 2.310 67. TOLERANCES — SEE 2.310 68. FINISHES — UNLESS NOTED 69. MATERIALS — SEE 2.310 70. THREADS — SHARP POINTS .015 MAX 71. IMPREGNATION — SEE 2.310 72. TOLERANCES — SEE 2.310 73. FINISHES — UNLESS NOTED 74. MATERIALS — SEE 2.310 75. THREADS — SHARP POINTS .015 MAX 76. IMPREGNATION — SEE 2.310 77. TOLERANCES — SEE 2.310 78. FINISHES — UNLESS NOTED 79. MATERIALS — SEE 2.310 80. THREADS — SHARP POINTS .015 MAX 81. IMPREGNATION — SEE 2.310 82. TOLERANCES — SEE 2.310 83. FINISHES — UNLESS NOTED 84. MATERIALS — SEE 2.310 85. THREADS — SHARP POINTS .015 MAX 86. IMPREGNATION — SEE 2.310 87. TOLERANCES — SEE 2.310 88. FINISHES — UNLESS NOTED 89. MATERIALS — SEE 2.310 90. THREADS — SHARP POINTS .015 MAX 91. IMPREGNATION — SEE 2.310 92. TOLERANCES — SEE 2.310 93. FINISHES — UNLESS NOTED 94. MATERIALS — SEE 2.310 95. THREADS — SHARP POINTS .015 MAX 96. IMPREGNATION — SEE 2.310 97. TOLERANCES — SEE 2.310 98. FINISHES — UNLESS NOTED 99. MATERIALS — SEE 2.310 100. THREADS — SHARP POINTS .015 MAX 101. IMPREGNATION — SEE 2.310 102. TOLERANCES — SEE 2.310 103. FINISHES — UNLESS NOTED 104. MATERIALS — SEE 2.310 105. THREADS — SHARP POINTS .015 MAX 106. IMPREGNATION — SEE 2.310 107. TOLERANCES — SEE 2.310 108. FINISHES — UNLESS NOTED 109. MATERIALS — SEE 2.310 110. THREADS — SHARP POINTS .015 MAX 111. IMPREGNATION — SEE 2.310 112. TOLERANCES — SEE 2.310 113. FINISHES — UNLESS NOTED 114. MATERIALS — SEE 2.310 115. THREADS — SHARP POINTS .015 MAX 116. IMPREGNATION — SEE 2.310 117. TOLERANCES — SEE 2.310 118. FINISHES — UNLESS NOTED 119. MATERIALS — SEE 2.310 120. THREADS — SHARP POINTS .015 MAX 121. IMPREGNATION — SEE 2.310 122. TOLERANCES — SEE 2.310 123. FINISHES — UNLESS NOTED 124. MATERIALS — SEE 2.310 125. THREADS — SHARP POINTS .015 MAX 126. IMPREGNATION — SEE 2.310 127. TOLERANCES — SEE 2.310 128. FINISHES — UNLESS NOTED 129. MATERIALS — SEE 2.310 130. THREADS — SHARP POINTS .015 MAX 131. IMPREGNATION — SEE 2.310 132. TOLERANCES — SEE 2.310 133. FINISHES — UNLESS NOTED 134. MATERIALS — SEE 2.310 135. THREADS — SHARP POINTS .015 MAX 136. IMPREGNATION — SEE 2.310 137. TOLERANCES — SEE 2.310 138. FINISHES — UNLESS NOTED 139. MATERIALS — SEE 2.310 140. THREADS — SHARP POINTS .015 MAX 141. IMPREGNATION — SEE 2.310 142. TOLERANCES — SEE 2.310 143. FINISHES — UNLESS NOTED 144. MATERIALS — SEE 2.310 145. THREADS — SHARP POINTS .015 MAX 146. IMPREGNATION — SEE 2.310 147. TOLERANCES — SEE 2.310 148. FINISHES — UNLESS NOTED 149. MATERIALS — SEE 2.310 150. THREADS — SHARP POINTS .015 MAX 151. IMPREGNATION — SEE 2.310 152. TOLERANCES — SEE 2.310 153. FINISHES — UNLESS NOTED 154. MATERIALS — SEE 2.310 155. THREADS — SHARP POINTS .015 MAX 156. IMPREGNATION — SEE 2.310 157. TOLERANCES — SEE 2.310 158. FINISHES — UNLESS NOTED 159. MATERIALS — SEE 2.310 160. THREADS — SHARP POINTS .015 MAX 161. IMPREGNATION — SEE 2.310 162. TOLERANCES — SEE 2.310 163. FINISHES — UNLESS NOTED 164. MATERIALS — SEE 2.310 165. THREADS — SHARP POINTS .015 MAX 166. IMPREGNATION — SEE 2.310 167. TOLERANCES — SEE 2.310 168. FINISHES — UNLESS NOTED 169. MATERIALS — SEE 2.310 170. THREADS — SHARP POINTS .015 MAX 171. IMPREGNATION — SEE 2.310 172. TOLERANCES — SEE 2.310 173. FINISHES — UNLESS NOTED 174. MATERIALS — SEE 2.310 175. THREADS — SHARP POINTS .015 MAX 176. IMPREGNATION — SEE 2.310 177. TOLERANCES — SEE 2.310 178. FINISHES — UNLESS NOTED 179. MATERIALS — SEE 2.310 180. THREADS — SHARP POINTS .015 MAX 181. IMPREGNATION — SEE 2.310 182. TOLERANCES — SEE 2.310 183. FINISHES — UNLESS NOTED 184. MATERIALS — SEE 2.310 185. THREADS — SHARP POINTS .015 MAX 186. IMPREGNATION — SEE 2.310 187. TOLERANCES — SEE 2.310 188. FINISHES — UNLESS NOTED 189. MATERIALS — SEE 2.310 190. THREADS — SHARP POINTS .015 MAX 191. IMPREGNATION — SEE 2.310 192. TOLERANCES — SEE 2.310 193. FINISHES — UNLESS NOTED 194. MATERIALS — SEE 2.310 195. THREADS — SHARP POINTS .015 MAX 196. IMPREGNATION — SEE 2.310 197. TOLERANCES — SEE 2.310 198. FINISHES — UNLESS NOTED 199. MATERIALS — SEE 2.310 200. THREADS — SHARP POINTS .015 MAX 201. IMPREGNATION — SEE 2.310 202. TOLERANCES — SEE 2.310 203. FINISHES — UNLESS NOTED 204. MATERIALS — SEE 2.310																			